



79132

NEW FORM OF CARBON

1 This is a continuation-in-part of copending United States Patent Application having Serial Number 575,254 that was filed on August 30, 1990.

5 BACKGROUND OF THE INVENTION

This invention relates to new forms of carbon as well as methods for the production and recovery thereof from carbon sources.

10 In 1985, Kroto et al. postulated the existence of a highly stable molecule composed of 60 carbon atoms based solely on mass spectroscopic analysis of vaporized graphite (H.W. Kroto, et al., Nature, Vol. 318, 162, 14 November 1985). More specifically, all that was observed
15 was a peak in the mass spectra of said carbon vapor. However, Kroto et al. did not isolate any of said compound.

A model for this compound was proposed in which 60 carbon atoms are placed at the vertices of a truncated
20 icosahedron forming a perfect "soccerball" structure. Subsequent thereto, many publications have strengthened the evidence for the existence of this molecule. The 60 carbon atom compound (hereinafter C_{60}) was presumably produced in situ for the spectroscopic determination
25 reported in these publications. Yet, to date, no one has been successful in verifying the existence of this molecule since no one has been successful in isolating the molecule in measurable amounts. Thus, no processes for producing recoverable amounts of this new compound
30 have been described to the present time.

In the aforesaid publication by Kroto, et al., the authors proposed many uses for the new substance, C_{60} if it could be produced in quantity such as C_{60} transition metal compounds, e.g., $C_{60}Fe$; or halogenated
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species like $C_{60}F_{60}$ which might be a super lubricant;
1 molecules including oxygen and lanthanum in the C_{60}
interior; C_{60} would provide a topologically novel
aromatic nucleus for new branches of organic and
inorganic chemistry; and C_{60} being especially stable and
5 symmetrical provides possible catalyst and/or
intermediate in modelling prebiotic chemistry.

Another form of carbon containing 70 carbon atoms
(C_{70}) has also been postulated (Kroto, Chemistry in
Britain, 40-45 (1990), Kroto, Science, 1139-1145 (1988)).
10 Like the (C_{60}) to date, no one has been successful in
verifying the existence of the C_{70} . Heretofore, no one
has been successful in obtaining the molecule in any
appreciable amounts.

15 SUMMARY OF THE INVENTION

A process has now been developed for the
production of recoverable amounts of C_{60} and C_{70} . The
present new process is accomplished by evaporating carbon
20 rods in an atmosphere of an inert quenching gas
maintained at reduced pressure in a reactor therefor.
This process produces a sooty carbon product which is
graphitic carbon including a few percent of C_{60} and low
levels of C_{70} which are recoverable from the product.
25 However, an increase in the fraction of C_{70} molecules can
be produced if the pressure is raised to greater than
atmospheric pressures.

The recovery process is preferably accomplished
by selective extraction of C_{60} and C_{70} with non-polar
30 organic solvents from the sooty graphitic carbon.

The processes of the present invention produces
 C_{60} and C_{70} in recoverable amounts and permits
realization of the proposed uses described hereinbefore.

BRIEF DESCRIPTION OF THE FIGURES

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Fig. 1: ~~Micrograph~~ ^{micrograph} of typical crystals of the 98% C₆₀, 2% C₇₀ material showing thin platelets, rods and stars of hexagonal symmetry.

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Fig. 2: X-ray diffraction of a microcrystalline powder of the 98% C₆₀, 2% C₇₀ solid material. Inset at upper left is a single crystal electron diffraction pattern indexed with Miller indices compatible with the X-ray pattern, taken on a thin platelet as in Figure 1 with the electron beam perpendicular to the flat face.

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Fig. 3: Infrared absorption spectrum of an approximately 2 micrometer thick coating of the 98% C₆₀, 2% C₇₀ material on a silicon substrate, referenced to a clean silicon substrate. Absorption is given as optical density = log₁₀ 1/T, where T is transmission. Apparent negative absorptions are due to the coating acting in part as a non-reflecting layer.

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Fig. 4: Visible-ultraviolet absorption spectrum of an approximately 0.1 micrometer thick coating of the 98% C₆₀, 2% C₇₀ material on quartz. Shown at the bottom are positions and relative oscillator strengths for allowed transitions calculated for the C₆₀ molecule by Larsson, et al.

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25 DESCRIPTION OF THE PREFERRED EMBODIMENTS

The first step in the production of C₆₀ and C₇₀ molecules is vaporizing carbon from any source containing carbon in its various forms, e.g., graphite, amorphous and glassy carbon. It is preferred that this vaporization takes place in an evacuated reactor (e.g., a bell jar). The carbon is vaporized by heating in the presence of an inert quenching gas. The carbon vapor is nucleated in the presence of the inert quenching gas to form smoke particles.

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1 In the production of C_{60} and C_{70} , any procedure
for vaporizing carbon can be used, although the preferred
method relies on the use of a high intensity electrical
current with graphite rods as electrodes. These rods are
constructed to permit vaporization of carbon at the tip
5 of the rod to produce a high density vapor of carbon.
For best results, the end of one of the rods is reduced
in diameter so that the vaporization occurs at the
reduced tip. The rods can be prepared using any of the
various forms of carbon, such as graphite, amorphous and
10 glassy carbon.

The inert quenching gas can be any of the usual
inert gases such as the noble gas. Argon and helium are
preferred, the latter being most preferred. Other inert
gases commonly employed to provide a non-reactive
15 atmosphere can also be used as quenching gas.

The amount of C_{60} and C_{70} produced from this
carbon source is dependent upon the pressure of the
quenching gas. At lower pressures relatively pure C_{60}
molecules can be produced in high yield with minor
20 concentrations of C_{70} . For the production of
predominantly C_{60} molecules, the pressure at which the
quenching gas is maintained should be subatmospheric and
preferably about 50-400 torr. Especially preferred is a
pressure of approximately 100 torr. The use of any lower
25 pressure may result in reduced yield of C_{60} .

However, as the pressure is raised, the ratio
of $C_{70}:C_{60}$ is also increased.

If the pressure is increased to at least two
30 atmospheres, the greatest percentage of C_{70} product is
formed. Theoretically, the pressure can be raised to any
level just below the point where the reactor would

1 explode from the increased pressure. However, at the
higher pressures, the yield of the overall product (C_{60}
and C_{70}) is reduced even though the ratio of $C_{70}:C_{60}$ is
also increased. Therefore, as a practical consideration,
5 the pressure of the quenching gas should not be greater
than 10 atmospheres. The preferred pressure for
maximizing the amount of C_{70} produced is 2-3 atmospheres.

The produced quenched vapor of carbon, i.e.,
the smoked particles coats the internal surface of the
10 reactor and of collecting substrates as black soot.
These collecting surfaces are inert to the vaporized
carbon. They can be transparent and/or coated with an
inert metal. Examples include glass, or gold coated
glass surfaces and the like. These collecting surfaces
15 are located in the reactor in the path of the carbon
smoke. The black coating can be removed by any suitable
means, e.g., by scraping the solids from the coated
surfaces. The C_{60} and C_{70} molecules can be removed from
this collected quenched product by contacting said
20 quenched product with an extracting solvent. In other
words, the black soot is placed in a container containing
the extracting solvent, or the extracting solvent is
poured onto the black soot placed in a container. In
either case, the C_{60} and C_{70} molecules become dissolved in
25 the solvent, while the remainder of the black soot
remains insoluble. The insoluble material is separated
from the solution containing the C_{60} and C_{70} molecules,
e.g., by decanting, or by filtration, and the like.

Suitable solvents include non-polar organic
30 solvents, such as the alkanes containing 5-10 carbon
atoms (e.g. pentanes, hexanes, heptanes, octanes),
benzene and alkyl-benzenes (e.g. toluene, xylene), carbon
disulfide, carbon tetrachloride, naphtha,1,1,1-

1 trichloroethane, and the like. Simple solubility
determinations using classical laboratory methods will
permit selection of other suitable solvents. The
preferred solvents are carbon disulfide, benzene, carbon
5 tetrachloride and toluene. Especially preferred are
benzene, carbon tetrachloride and carbon disulfide.

The product obtained contains a mixture of C_{60}
and C_{70} . As described hereinabove, the amounts of C_{60}
and C_{70} present is dependent upon the pressure used. If
10 subatmospheric pressures are used, such as 50-400 torr,
the product is predominately pure C_{60} with a minor amount
of C_{70} present. Thus, when the collected product is
dispersed in the extracting solvent, the product obtained
is a mixture of C_{60} and C_{70} . For example, when the
15 pressure is 100 torr, the product formed is about 98% C_{60}
and about 2% C_{70} . This product can be separated from the
organic solvent solution by standard methods as by
evaporation of the solvent or by dilution of the solvent
solution with a non-solvent for C_{60} . The product can be
20 crystallized by careful evaporation of the organic
solvent or by sublimation procedures.

In a preferred embodiment of producing C_{60} and
 C_{70} , pure graphite rods are vaporized by passing high
25 electrical current (either dc or ac) through narrowed
tips of graphite rods. Electron beam, laser and RF
heating can be used in lieu of electrical heating. This
is done in a reactor (such as a bell jar) that has been
evacuated, purged and filled with inert gas at or
30 preferably below atmospheric pressure, e.g., pressures
ranging from about 50 to about 400 torr. and even higher.
The graphite rods are typically 1/4 inch in diameter with

1 about 1 cm length of one rod reduced in diameter to about
5 mm. The electrical heating vaporizes the constricted
tip of the graphite rod producing a high density vapor of
5 carbon, which quickly condenses into a smoke consisting
of very fine particles (of the order of 0.1 microns) of
graphitic carbon with an admixture of a few percent of
the desired C_{60} molecule. At this point in the process
there is a heavy black coating on collecting substrates
and/or on the walls of the chamber which can be easily
10 scraped off for the recovery step.

For recovery, the sooty product is treated with
benzene to provide a brownish-red solution. After
separation of the undissolved graphitic carbon, the
benzene solution is evaporated to obtain microcrystalline
15 product. Alternatively, the product can be sublimed from
the sooty carbon at 300° to 400°C. and the sublimation
product obtained by condensation on a conventional
substrate.

When the pressure of inert quenching gas is 100
20 torr, the product formed is 98% C_{60} and 2% C_{70} . This
product, as obtained from the solvent extract of the
sooty graphitic carbon, is a dark brown to black
crystalline material. When obtained by sublimation in
vacuum or inert atmosphere, the product is obtained as a
25 brown to gray coating depending on thickness.

On analysis by mass spectroscopy, the spectrum
clearly shows a strong peak at mass 720 amu (i.e., the
mass of C_{60}) and a clean peak at 840 amu (i.e., the mass
of C_{70}). Significant differences in the spectra occur
30 only in the abundances in the mass domain lower than 300
amu. Most of these differences seem to originate from
the different ionization techniques in the mass
spectrometer and from the different kinds of sample
desorption. So far, the cleanest mass spectra have been

1 obtained when the material was evaporated and ionized in
the vapor phase by electrons. In such spectra the mass
range above 40 amu is dominated by the C_{60} mass along
with its expected isotope lines. The only other large
5 mass found in any abundance corresponds to C_{70} , with a
ratio of C_{70} to C_{60} of about .02.

Studies by optical microscopy of the C_{60}
material which is left after evaporating the benzene
solution show a variety of what appear to be crystals --
10 mainly rods, platelets, and star-like flakes. Figure 1
shows a micro-photograph of such a crystal assemblage.
All crystals tend to exhibit six-fold symmetry. In
transmitted light they appear red to brown in color; in
reflected light the larger crystals have a metallic
15 appearance, whereas the platelets show interference
colors consistent with an index of refraction of about 2.

The platelets can be rather thin and thus are ideally
suited for electron diffraction studies in an electron
20 microscope. (See the insert in Figure 2).

In order to determine if the C_{60} molecules form
a regular lattice electron, x-ray diffraction studies on
the individual crystals and on the powder were carried
out. A typical X-ray diffraction pattern of the purified
25 C_{60} powder is shown in Figure 2. To aid in comparing the
electron diffraction results with the X-ray results the
electron diffraction pattern is inserted into the corner
of Figure 2. From the hexagonal array of diffraction
spots indexed as shown in the Figure, a d-spacing of 8.7
30 Å was deduced corresponding to the (100) reciprocal
lattice vector of a hexagonal lattice. The most obvious
correspondence between the two types of diffraction is
between the 5.01 Å peak of the X-ray pattern and the

1 (100) spot of the electron diffraction pattern, which
 gives a spacing of about 5.0 Å. Assuming that the C₆₀
 molecules are behaving approximately as spheres stacked
 in a hexagonal close packed lattice with a c/a ratio of
 5 1.633, d-spacings can be calculated. The results are
 shown in Table I.

Table I: X-Ray Diffraction Results and
 Assignments For a Hexagonal Lattice Using
 a = 10.02 Å, c = 16.36 Å

$$\frac{1}{d^2} = \frac{4}{3} \left(\frac{h^2 + hk + k^2}{a^2} \right) + \frac{c^2}{c^2}$$

15	Measured 20 (degrees)	Measured d-spacing (Å)	Calculated d-spacing (Å)	Assignment (hkl)
	10.2 shoulder	8.7	8.68	(100)
20	10.81	8.18	8.18	(002)
			7.67	(101)
	17.69	5.01	5.01	(110)
	20.73	4.28	4.27	(112)
	21.63	4.11	4.09	(004)
25	28.1	3.18	3.17	(114)
	30.8	2.90	2.89	(300)
	32.7	2.74	2.73	(006)

The values derived from this interpretation are
 a = 20.02 Å and c = 16.36 Å. The nearest neighbor
 distance is thus 10.02 Å. For such a crystal structure
 30 the density is calculated to be 1.678 g/cm³, which is
 consistent with a value of 1.65 +/- .05 determined by
 suspending crystal samples in aqueous GaCl₃ solutions of

1 known densities. Although the agreement shown in Table 1
is good, the absence of the characteristically strong
(101) diffraction in hcp and the broad continuum in
certain regions suggest a less than perfect crystalline
5 order. Furthermore, X-ray diffraction patterns obtained
on carefully grown crystals up to 500 micrometers in size
with well developed faces yielded no clear spot pattern
(in contrast to the electron diffraction pattern on
micron-size crystals). It thus appears that these larger
10 crystals do not exhibit long range periodic order in all
directions.

A likely explanation for the unusual
diffraction lies in the disordered stacking arrangement
of the molecules in planes normal to the c-axis. It is
15 well known that the position taken by spheres in the
third layer of stacking determines which of the
close-packed structures occurs, the stacking arrangement
in fcc being ABCABC while that in hcp is ABABAB. If the
stacking sequence varies, the X-ray lines due to certain
20 planes will be broadened by the disorder while other
lines will remain sharp. Such disordered crystalline
behavior was observed long ago in the close packed
structure of cobalt, where X-ray diffraction lines such
as (101), (102) and (202) were found to be substantially
25 broadened due to the stacking disorder. Reflections from
planes such as (002) remain sharp since these planes have
identical spacings in both fcc and hcp structures. A
general expression for which peaks are broadened by this
kind of disorder have been given in terms of Miller
30 indices (h,k,l) as $h - k = 3t \pm 1$, $l \neq 0$, where t is an
integer. None of these broadened reflections are
apparent in the X-ray pattern of Figure 2. This may
explain the weakness of the characteristically strong

1 (101) peak. Whether or not this stacking disorder is
related to the presence of the possibly elongated C_{70}
molecules is yet to be determined.

5 In small crystals at least, the C_{60} molecules
appear to be assembling themselves into a somewhat
ordered array as though they are effectively spherical,
which is entirely consistent with the soccer ball
hypothesis for their structure. The additional diameter
over the calculated 7.1 \AA value for the carbon cage
10 itself must represent the effective van der Waals
diameter set by the repulsion of the pi electron clouds
extending outward from each carbon atom. Scanning
tunnelling spectroscopy of the C_{60} molecules clearly
shows the spherical nature of the C_{60} molecules.

15 Some scanning tunnelling microscope images of a
carbon sample prepared in accordance with the procedure
described hereinabove at pressures of helium at 100 torr
show a spherical molecule of twice the diameter of the
 C_{60} molecules. This is evidence of the existence of a
20 caged molecule containing 240 carbon atoms or a C_{240}
molecule.

Samples were prepared for spectroscopy by
subliming pure material onto transparent substrates for
transmission measurements. Depending on the pressure of
helium in the sublimation chamber, the nature of the
25 coatings can range from uniform films (at high vacuum) to
coatings of C_{60} smoke (i.e., sub-micron microcrystalline
particles of solid C_{60}) with the particle size depending
to some extent on the pressure.

30 Figure 3 shows the transmission spectrum of an
approximately 2 micrometer thick C_{60} coating on a silicon
substrate. The infrared bands show the four most intense
lines at 1429 , 1183 , 577 , and 528 cm^{-1} , with no

1 underlying continuum remaining from the soot. In early
tries at purifying C_{60} material, the infrared spectrum
showed a strong band in the vicinity of 3.0 micrometers,
which is characteristic of a CH stretching mode. After
5 much effort, this contaminant was successfully removed by
washing the soot with ether and using distilled benzene
in the extraction. The spectrum in Figure 3 was obtained
when the material cleaned in such a manner was sublimed
under vacuum onto the substrate. The spectrum shows very
10 little indication of CH impurities.

The presence of only four strong bands is what
is expected for the free, truncated icosahedral molecule
with its unusually high symmetry. Also present are a
number of other weak infrared lines which may be due to
15 other causes, among which may be absorption by the C_{70}
molecule or symmetry breaking produced, for example, by
isotopes other than C^{12} in the C_{60} molecule or by mutual
interaction of the C_{60} molecules in the solid.
Noteworthy, are weaker features at about 2330 and 2190
20 cm^{-1} which are located in the near vicinity of the free
 CO_2 and CO stretching modes. This may imply some
attachment of CO_2 or CO to a small fraction of the total
number of C_{60} molecules. Another noteworthy effect can
be observed in the feature at 675 cm^{-1} , which is weak in
25 the thin film samples but almost as strong as the four
main features in the crystals. This vibrational mode may
be of solid state rather than molecular origin.

Figure 4 shows an absorption spectrum taken on
a uniform film coated onto a quartz glass substrate. The
30 ultraviolet features are no longer obscured by the
graphitic carbon background as in our previous spectra.
Broad peaks at 216, 264 and 339 nm dominate the spectra.
Weaker structures show up in the visible, including a

1 plateau with ends at about 460 and 500 nm and a very weak
peak near 625 nm. At the bottom of Figure 4 are shown
positions and relative oscillator strengths taken from
Larsson, et al. (Chem. Phys. Lett. 137, 501-504)
5 calculated for the C_{60} molecule. This reference also
shows a variety of forbidden bands with the lowest energy
ones in the vicinity of 500 nm. There seems to be a
rough correspondence between the present measurements on
thin films and the allowed transitions predicted for the
10 molecule. There was no band at 386 nm in our films of
 C_{60} , as disclosed by Heath, et al. (J. Chem. Phys. 87,
4236-4238 (1987)) using a laser depletion spectroscopy
method and attributed to the C_{60} molecule. Quite similar
spectra to that in Figure 4 have been recorded for
15 microcrystalline coatings deposited at helium pressures
of 100 torr, for example. The peaks occur at the
slightly shifted positions of 219, 268, and 345 nm.

The C_{70} molecule is larger than the C_{60}
molecule. The C_{70} molecule shows a molecular ion peak at
20 840 amu. Furthermore, a noticeable peak in the
ultraviolet spectrum of the C_{70} molecule taken on a
uniform film coated onto a quartz glass substrate is
exhibited at about 216 nm. This is a broad peak.
Surprisingly, it appears that the C_{70} molecule is more
25 stable than C_{60} .

Thus, using the procedures described
hereinabove, at quenching pressures of less than 1
atmospheric pressure and especially at pressures of
50-400 torr, a product is produced which is predominantly
30 C_{60} and ^{contains} contains minor amounts of C_{70} . The C_{60} product
can be used or can be further purified.

Further purification and separation of C_{60} and
 C_{70} can be made by many conventional techniques known to

1 one skilled in the art, e.g., fractional crystallization,
column chromatography, capillary electrophoresis, HPLC,
preparative thin-layer chromatography, and the like.

5 Because the molecular figuration of C_{60} and C_{70}
are different, the attractive intermolecular forces are
different which allows for the two molecules to be
readily separated.

10 Furthermore, the solubility of C_{60} and C_{70} in
pure solvents and mixed solvents are also different from
each other, which also makes the two compounds separable
by using conventional techniques known to one skilled in
the art, such as crystallization, extraction, and the
like.

15 For example, pure C_{60} and pure C_{70} molecules
can be isolated as follows. The black sooty mixture of
 C_{60} and C_{70} which is produced according to the procedure
described hereinabove is placed in the extracting
solvent, such as benzene. The insoluble residue is
removed and the resulting benzene solution containing C_{60}
20 and C_{70} molecules is concentrated. The C_{60} and C_{70}
solution is added to a packed column with an adsorbent,
such as alumina. The column is eluted with an eluent
such as benzene or a mixture of benzene and toluene.
Various fractions of set volume e.g., 10 mL, are
25 collected. The eluent i.e., the solvent is removed from
each fraction such as by evaporation to dryness. The
fractions with product will contain microcrystals, the
identity of which can be confirmed by spectroscopy, e.g.,
mass spectroscopy.

30 Thus, the process of the present invention can
produce a product which is predominantly C_{60} , which, if
desired, can be further purified by the purification and
separation techniques described hereinabove.

1 Furthermore, the present invention contemplates
two different variations of the procedure described
hereinabove to make C_{70} molecules. First, if
subatmospheric pressures of quenching gases are used in
the initial step, small amounts of C_{70} are produced,
5 which can be separated from the C_{60} molecules using the
purification techniques described hereinabove. However,
if the pressure of the quenching gas is raised to at
least 2 atmospheres, after separation and purification, a
greater percentage of substantially pure C_{70} would be
10 produced from each vaporization of carbon.

The present new products, C_{60} , C_{70} , or mixtures
thereof have the similar utilities as graphite. However,
they are particularly valuable for forming products of a
higher order of stability than those formed from
15 graphitic carbon, and can be processed into formed or
molded products such as C_{60} fibers, C_{70} fibers, or
mixtures thereof using standard processing techniques.
In this regard, free-flowing, particulate C_{60} and C_{70} are
of special value particularly for use in producing molded
20 products, especially those extended in at least one
direction. C_{60} , and C_{70} are also useful for producing a
low temperature C_{60} vapor (300° - 400° C.) and C_{70} vapor of
the respective molecules to produce low temperature
25 atomic and molecular beams of carbon which is not now
possible using graphite as the carbon source. Further,
the synthesis of compounds such as $C_{60}H_{60}$ and $C_{60}F_{60}$ can
be accomplished by introducing hydrogen and fluorine,
respectively, into a reactor containing C_{60} vapor.
30 Furthermore, the C_{60} product and the C_{70} product may be
used as an industrial paint pigment or as a lubricant.
Moreover, since the C_{60} and C_{70} molecule are hollow, they
could be used for binding and/or storing molecules e.g.,
toxic material.

EXAMPLE 1

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C_{60} -containing carbon dust was produced in a conventional bell-jar carbon evaporator which was first evacuated to 10^{-4} torr by either an oil diffusion pump or
5 a turbo pump, both equipped with liquid nitrogen traps, and then filled with an inert quenching gas. Helium and argon were used at pressures ranging up to 400 torr. Then graphite rods (as previously described herein) were evaporated using a current of about 100 amps (either AC
10 or DC).

The smoke which formed in the vicinity of the evaporating carbon rods was collected on substrates which were placed within 5 cm to 10 cm of the evaporating carbon rods.

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The evaporator was opened after a cool down period of 10-30 min. and the carbon dust samples removed by scraping substrate surfaces and the internal surfaces of the bell-jar. After washing with ether, the collected dust samples were then extracted with benzene to produce
20 a wine-red to brown solution. On evaporation of the solution, C_{60} was obtained as a microcrystalline residue.

The crystals were sublimed by heating in vacuo or in a quenching inert gas to 400°C. and collected on a substrate. The sublimed product was brown to gray in
25 color.

In powder form, the present new carbon allotrope is brownish-red.

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EXAMPLE 2

1 The procedure of Example 1 is repeated except,
in the original step, the graphite rods are evaporated at
2 or more atmospheres of helium pressure in the chamber.
The product obtained from this procedure contains a
5 greater percentage of C_{70} than does the product in
Example 1.

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EXAMPLE 3

1 Pure C₆₀ and pure C₇₀ are obtained as follows:

5 The C₆₀ and C₇₀ mixtures prepared in either Examples
1 or 2 are dissolved in benzene and added to an alumina
column. Using benzene as the eluent, the fractions are
collected and each elute fraction is evaporated to
dryness. The presence of C₆₀ or C₇₀ in the fraction can
be determined by taking mass spectroscopy thereof.

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1 The above embodiments and examples are given to
illustrate the scope and spirit of the instant invention.
These embodiments and examples are within the
contemplation of the present invention. Therefore, the
5 present invention should be limited only by the appended
claims.

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